

Date: Thursday, 19/06/2008 9:53:37 AM
 User: Julie Leccocq

Process Sheet

Split

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BEARING ASSEMBLY
 Job Number : 39948
 Estimate Number : 10716
 P.O. Number :
 This Issue : 19/06/2008 S.O. No. :
 Prsht Rev. : NC
 First Issue : 11 Type : MACHINED PARTS
 Previous Run : 39226
 Part Number : D3121241
 Drawing Number : D3121 REV E
 Project Number : N/A
 Drawing Revision : E
 Material :
 Due Date : 30/06/2008 Qty: 40 Um: Each
 Written By :
 Checked & Approved By : JWO 08.6.19
 Comment : Est Rev:A 04.02.18 New issue KJ/DS
 Est Rev:B ECN 1060 07-11-12 DD verified by:EC

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
1.0	MDELRLNR12500	DELRIN ROUND BAR 1.25"
Comment: Qty.: 0.0546 f(s)/Unit Total : 2.1840 f(s) Material: Ø1.25 Delrin Rod (M-DELRIN-R1.2500) Identify as D3121-25 Batch: <u>1107758</u> <u>mmf 08/06/22</u>		
2.0	HARDINGE	HARDINGE CNC LATHE SMALL
Comment: HARDINGE CNC LATHE SMALL 1-Turn D3121-25 Cap as per Folio FA387 2-Deburr <u>DTP/mmP 08/06/22</u> 100		
3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
Comment: INSPECT PARTS AS THEY COME OFF MACHINE <u>DTP/mmP 08/06/22</u> 100		
4.0	QC8	SECOND CHECK
Comment: SECOND CHECK <u>mmf 08/06/23</u> 100		
5.0	D312123	Bearing
Comment: Qty.: 1.0000 Each(s)/Unit Total : 40.0000 Each(s) Pick: Qty Part Number Description Batch 1 D3121-23 Bearing <u>240397</u> <u>SB 08/09/30</u> 40		

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BEARING ASSEMBLY

Job Number: 39948

Part Number: D3121241

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Press D3121-23 Bearing into D3121-25 Cap as per Dwg D3121

EB 08/09/30 (40)

7.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08/07/30 (x40) counters

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

ST 238

SS 08/09/30 (x40)

9.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/09/30

Job Completion



MLF 08-09-30

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

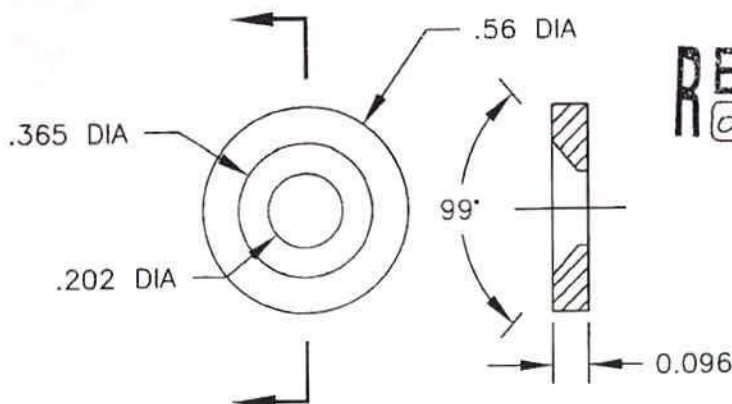
[illegible]

Measured by:	<i>mmk/DF</i>	Audited by:	<i>ml</i>	Prototype Approval:	N/A
Date:	<i>08/06/22</i>	Date:	<i>08/06/22</i>	Date:	N/A

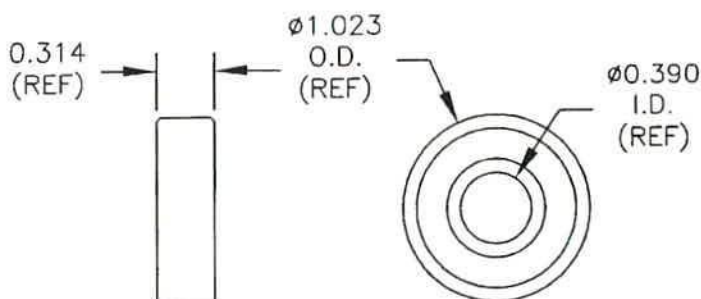
Rev	Date	Change	Revised by	Approved
A	04.04.20	New Issue (P/O D3121-241)	KJ/RF	
B	06.06.09	Ø1.000 diameter was Ø1.024	KJ/JLM	
C	08.01.16	Dwg Rev. updated	KJ/EC/DD	

DART

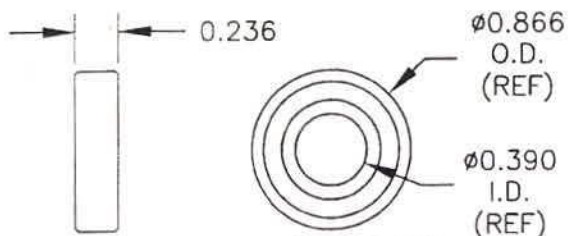
DESIGN #	DRAWN BY LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D3121	REV. E SHEET 10 OF 10
DATE 07.11.07	TITLE BRACKET ASSEMBLY		SCALE 1:1

**D3121-17 WASHER (SCALE 2:1)**

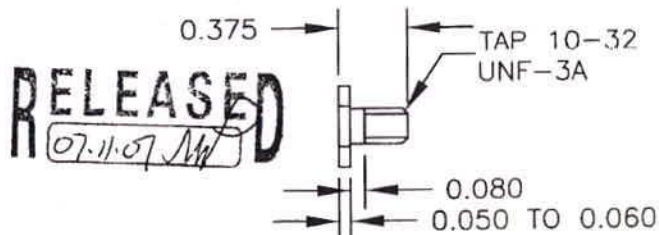
- 1) REPLACES PREMIER P/N B32-23001-17
- 2) MATERIAL: AISI 303 SS ROUND BAR, ANNEALED (REF DART SPEC. M303R)
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-19 BEARING (SCALE 1:1)**

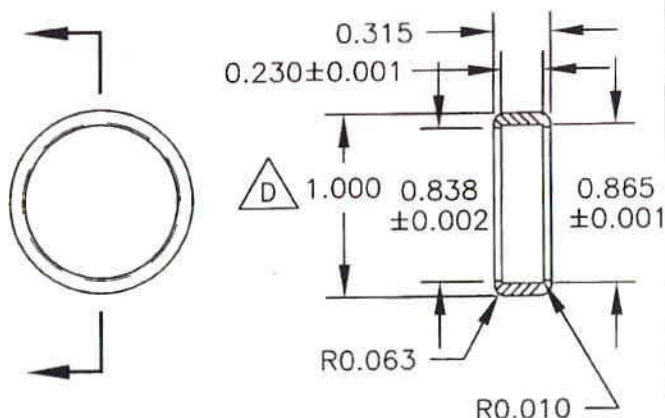
- 1) POSSIBLE SUPPLIER: KING BEARING P/N 6000-2ZJ/EM FAFNIR P/N 9100KDD
- 2) ALL DIMENSIONS ARE IN INCHES

**D3121-23 BEARING (SCALE 1:1)**

- 1) POSSIBLE SUPPLIER: SKF P/N 61900-2Z OR KML P/N 6900-ZZ
- 2) ALL DIMENSIONS ARE IN INCHES

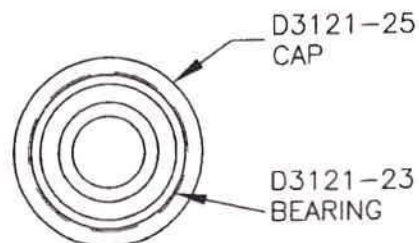
**D3121-21 BOLT (SCALE 1:1)**

- 1) MATERIAL: AISI 303 SS HEX, ANNEALED (REF DART SPEC. M303H0.500)
- 2) FINISH: NONE
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015

**D3121-25 CAP (SCALE 1:1)**

- 1) MATERIAL: DELRIN ROD, Ø1.25 (REF DART SPEC. M-DELRIN-R1.250)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES

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RETURN TO
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WORK ORDER
NO. 36948

**D3121-241 BEARING ASSEMBLY (SCALE 1:1)**

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